Date: Thursday, 4/12/2007 9:35:03 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 31796		
Estimate Number	: 10091		
P.O. Number	: N/A	Part Number	: D31835
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D3183 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: 30284	Material	: N/A
Written By	:	Due Date	: 4/18/2007 Qty: 60 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est: A 03.03.27 New issue KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 3521 CL 07/04/13
Bearing as per Dwg D3183
Single row, deep groove, Conrad type, shielded
Possible Supplier: NSK P/N 6800ZZ
Certificate of conformity note is required
(60)

2.0	6800ZZ	Bearing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)
BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of confomity is attached
07/4/25 (60)
07/04/17 (60)

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
07-04-27

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 78 ~~Qty 40~~ 60 in GA ml 07/04/27
~~07/4/27 (20)~~

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 07/04/07

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:35:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BEARING

Job Number: 31796 **Part Number:** D31835

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

(60)

Comment: FINAL INSPECTION/W/O RELEASE 07/04/27

Job Completion

U 07-04-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

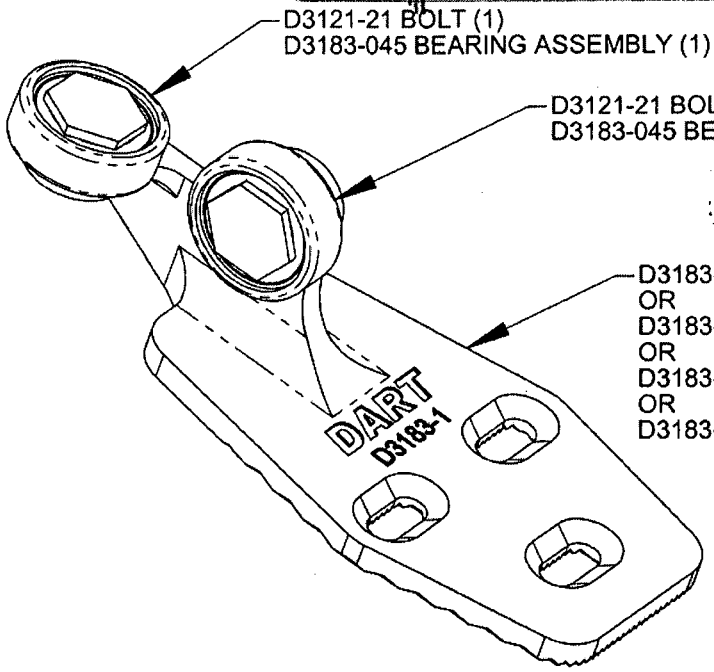
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CHECKED		APPROVED	DRAWING NO. D3183 REV. C SHEET 1 OF 4
DATE	04.02.17		TITLE BRACKET ASSEMBLY SCALE 1:1

DART

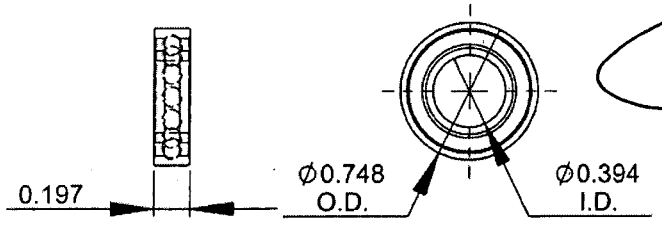
QA COPY ISSUED

RELEASED
04.03.01

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850



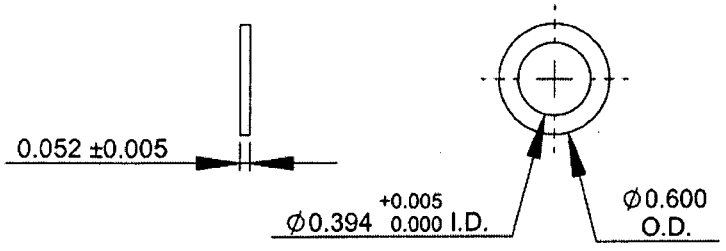
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
3) ALL DIMENSIONS ARE IN INCHES

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31796



D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

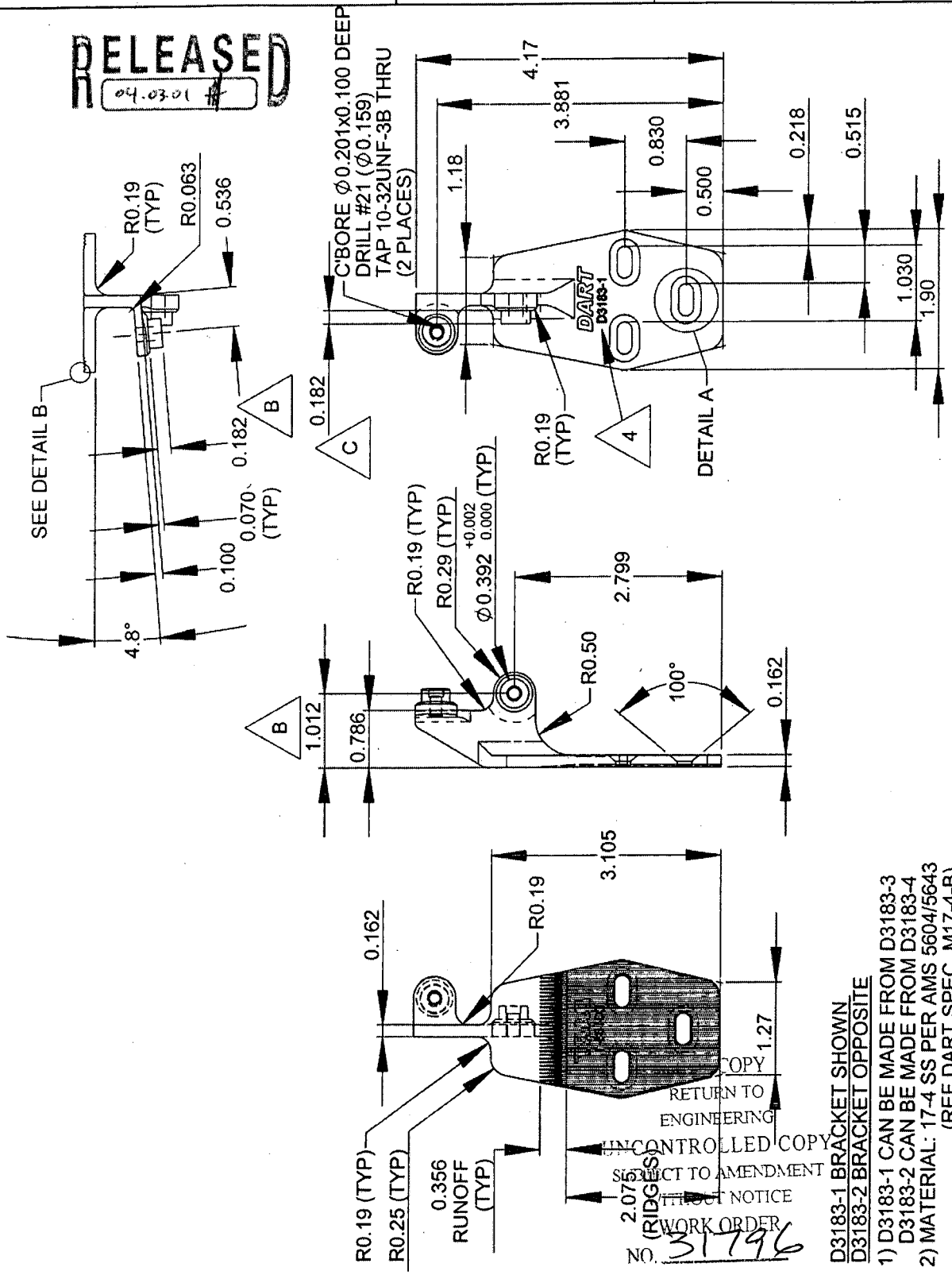
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

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04.03.01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

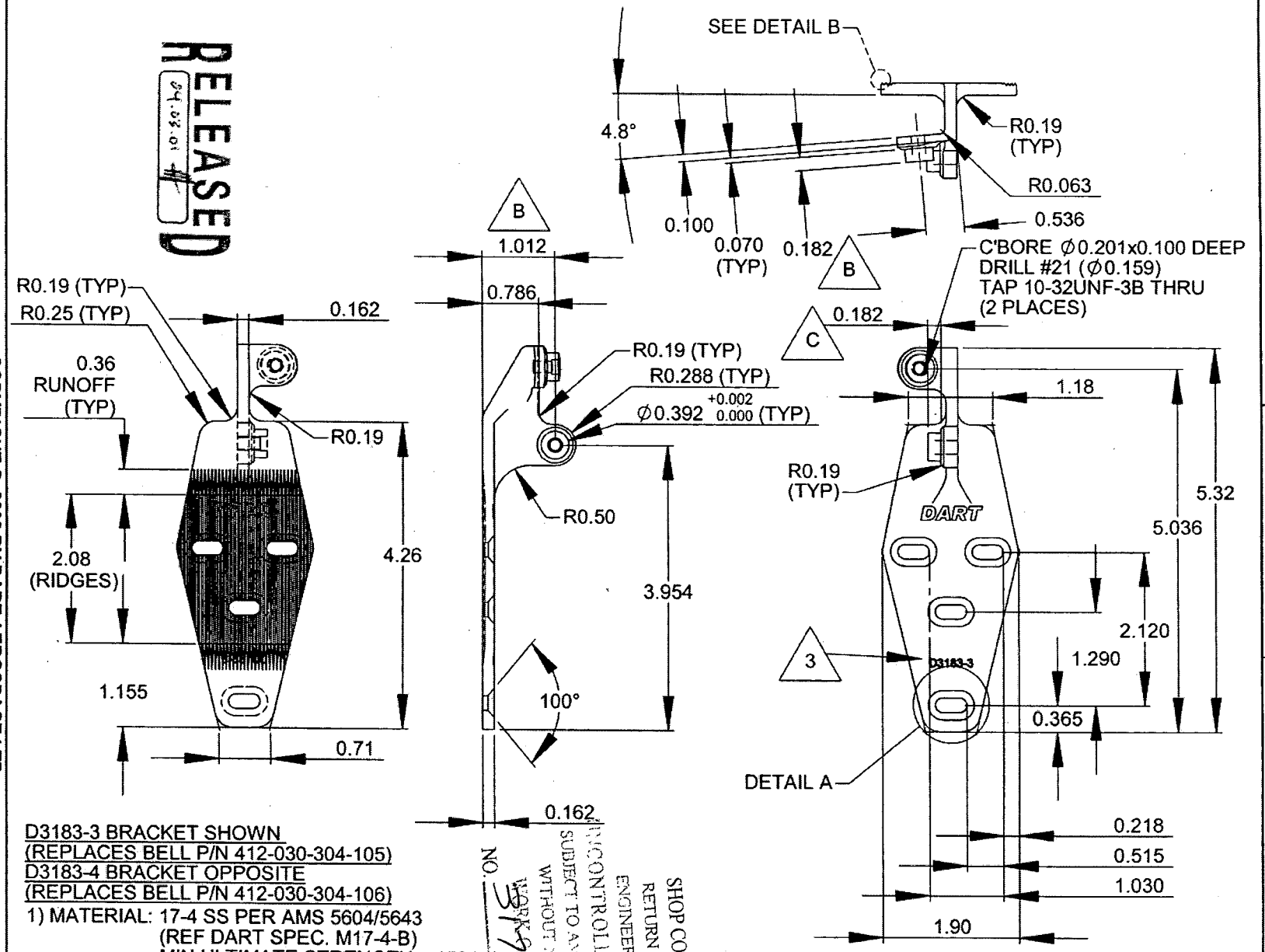
1) D3183-1 CAN BE MADE FROM D3183-3
   D3183-2 CAN BE MADE FROM D3183-4
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE STRENGTH = 150 ksi
   MIN YIELD STRENGTH = 100 ksi
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS
   OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER NO. 31796

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04.02.01

D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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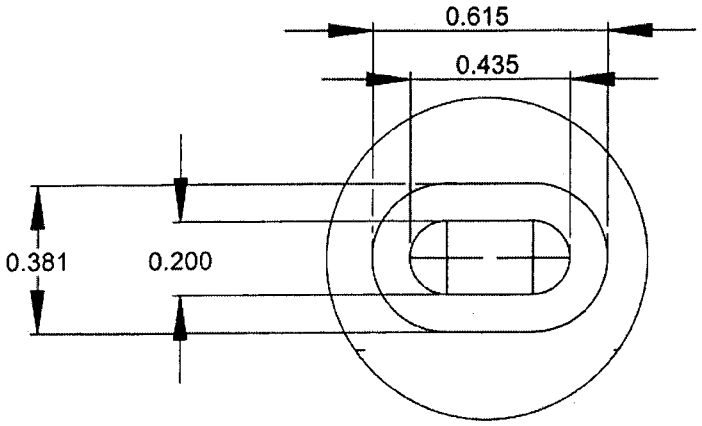
WORK ORDER NO. 317961

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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
			SCALE 1:2

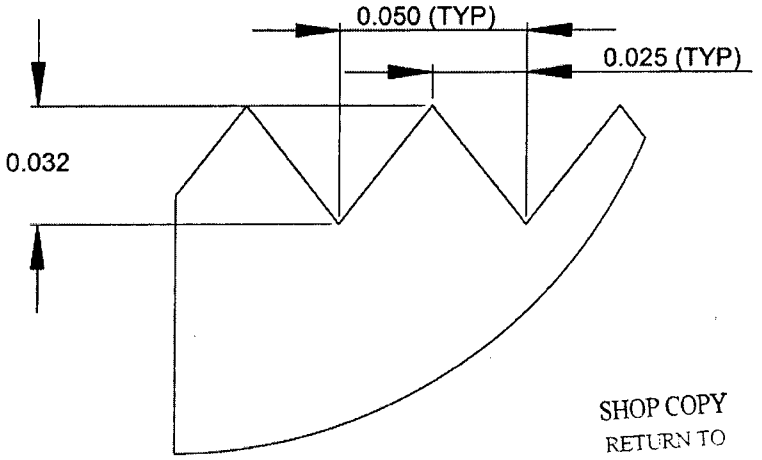
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



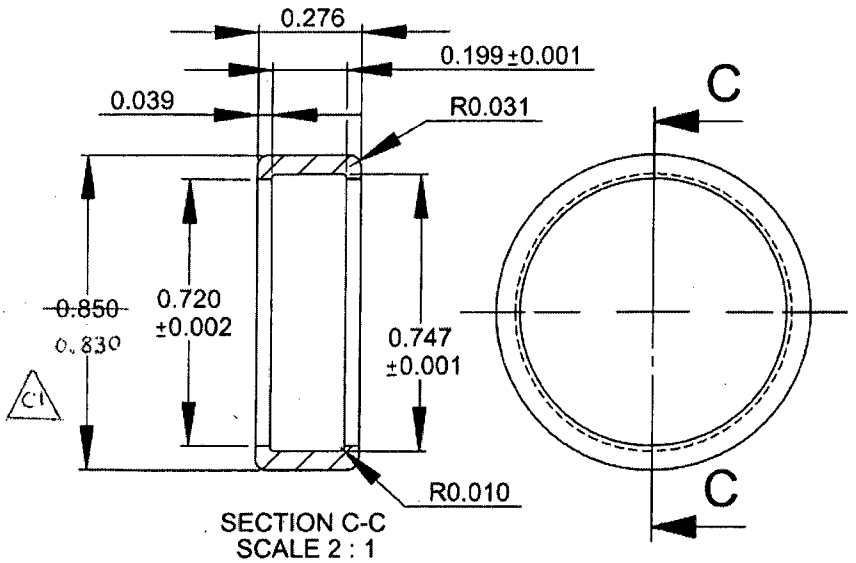
DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)

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WORK ORDER
NO. 31796



SECTION C-C
SCALE 2 : 1

D3183-9 CAP

1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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[redacted]

GENERAL BEARING SERVICE INC.

cie

GENERAL BEARING SERVICE inc.

www.gbs.ca

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979094

ORDER DATE: APR 17, 2007

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON. K6A-1K7

SALE MADE BY: PD
SHIP VIA:

CUSTOMER ORDER #: 3521

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6800-ZZ	BALL BEARING	60	60	4.89	293.40
6900-ZZ	BALL BEARING	50	50	4.97	248.50
				G.S.T.	32.51

7/04/17

PACKING SLIP NO: 370809-0

RECEIVED BY:

1050460

Non-Conformance Report

NCR 157

Raised by: Jason Murdock | Source: Q.C.

Sheet No. ___ of ___

Non-Conforming Dept./Supplier: General Bearing Service/Supplier

Date: 07.04.24

Product/Service: D3183-5 / Bearing # 6800ZZ

Priority: HIGH / LOW

Area of Standard:
QSI
QSP
QSPM

Documents:
P/O 3521
Invoice
W/O 31796
Batch No.
TSR
Drawing D3183 Rev C

Section A
Description of Non-Conformance Incorrect bearings were sent. Drawing and certs were for 6800ZZ bearings, and 6800 2RS (Rubber seal) bearings were sent.

Root cause:

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

Section B
Corrective Action

Responsible for Investigation/CA: L. Lacelle | To be done by: 07.05.04

No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M	Return bearing, and have supplier replace 6800 2RS, with the correct bearings 6800 ZZ, and explain a root cause of why certs/invoice state 6800ZZ were sent, and 6800 2RS were Received.	C. Lavoie	~~07.05.04~~ 07.04.26	~~07/04/26~~ EL

Preventive Action Required: NO YES #_____

Fault Category:

Section C
Verification of C/A

Responsible for Verification of CA:_____

No	Verification Method	Sign	Date

Forward to DQA on Completion of Verification

DQA: _____

Date: _____

QA Purposes only N/C Closed _____ Date _____

Nº DE COMMANDE - ORDER NO.	DÉP. - DEPT.	DATE 07/04/24
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO General bearings	
ADRESSE - ADDRESS	ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	Nº D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON

60X 6800-2RS returned for exchange for P/N: 6800ZZ for same price.

Thanks
Chantal.

6/7/25

TPS/GST

TVP/PST

59130

SIGNATURE	Nº LIC. - LIC. NO.	TOTAL

Blueline DCB156

FORMULAIRE DE VENTE – SALES ORDER

[redacted]

GENERAL BEARING SERVICE Inc.

www.gbs.ca

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979894

ORDER DATE: APR 17, 2007

SOLD TO: HART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON. K6A-1K7

SALE MADE BY: PD
SHIP VIA:

CUSTOMER ORDER #: 3521

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6800-ZZ	BALL BEARING	60	60	4.89	293.40
6900-ZZ	BALL BEARING	50	50	4.97	248.50
				G.S.T.	32.51

PACKING SLIP NO: 370009-0

RECEIVED BY:

1050460

Nº DE COMMANDE - ORDER NO.	DÉP. - DEPT.	DATE 07/04/24
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO General bearings	
ADRESSE - ADDRESS	ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	Nº D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON

	60X	6800-2RS returns for exchange for P/N: 6800ZZ for same price.			
		Thanks Chantal.			
			TPS/GST		
			TVP/PST		
59130	SIGNATURE	Nº LIC. - LIC. NO.	TOTAL		

Blueline DCB156

FORMULAIRE DE VENTE – SALES ORDER